

Date: Thursday, 05/06/2008 1:13:50 PM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BUSHING
Job Number : 39727	
Estimate Number : 11041	
P.O. Number :	Part Number : D2809
This Issue : 05/06/2008 S.O. No. :	Drawing Number : D2809 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS	Drawing Revision : A1
Previous Run : 35631	Material :
Written By : <i>[Signature]</i>	Due Date : 12/06/2008 Qty: 30 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est C 02.03.07 Now turned in house NG	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0500	6061-T6 Round Bar .500"
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Comment: Qty.: 0.1045 f(s)/Unit ~ Total : 3.1343 f(s)
 6061-T6 Round Bar .500"
 Material: 6061-T6 (QQ-A-250-11) rod .500"

Batch: *1107676* *mmf 08/06/08*

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL
 Machine as per Folio FA204

DTP/mmF 08/06/08

(30)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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DTP/mmF 08/06/08

(30)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

mmf 08/06/08

(30)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Tumble & deburr all sharp edges as per dwg

mmf 08/06/08

mmf 08/06/08

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 08/06/16 (30)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder coat WHITE per QSI 005 4.3

START TIME:

10:30

OVEN TEMPERATURE:

315 °C

FINISH TIME:

11:00

FL / KB

08/06/17

(30)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

M-A

08/06/17

(30K)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 48

8/6/17

(K30)

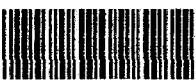
SD

08/06/19

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

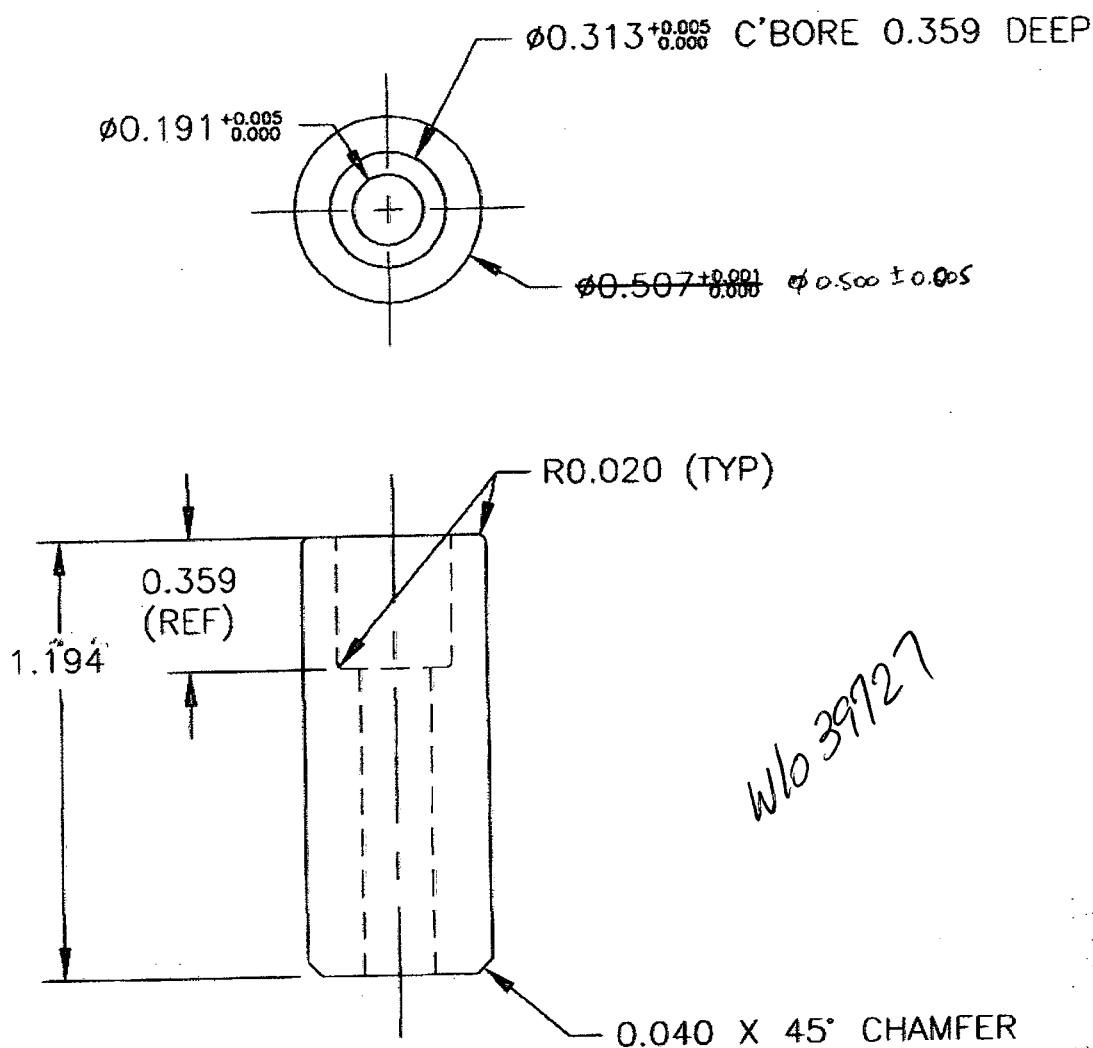


U 08.06.18



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2809	REV. A SHEET 1 OF 1
DATE 00.11.07		TITLE SPACER	SCALE 2:1
A	00.11.07	NEW ISSUE	
A1	CP 01.04.26	ADD POWDER COAT; $\phi 0.500$ W/TS $\phi 0.507$	

RELEASED
00.11.13



TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
BREAK ALL UNMARKED SHARP CORNERS 0.010 TO 0.020
MATERIAL: 6061-T6 (QQ-A-250/11) OR (QQ-A-225/8)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8)

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PER DART QSI 005 4.3

